

PATENT APPLICATION

OF

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For

**MULTI-STAGE POLYMER COMPOSITIONS HAVING A TRIGGERED
RESPONSE**

DN A01325

SEJ/bk

Express Mail Label No. EL659135199US

MULTI-STAGE POLYMER COMPOSITIONS HAVING A TRIGGERED
RESPONSE

The present invention relates to compositions exhibiting a chemical or physical response that is triggered upon exposing the compositions to an aqueous system containing one or more or a series of triggering events, each triggering event corresponding to a chemical/physical process or property. In particular, it relates to improving the stability and mechanical strength of polyelectrolyte compositions in an aqueous system by incorporating multi-stage polymer particles. The present invention is further directed to barrier materials and devices prepared from multi-stage polymer compositions that protect active ingredients and beneficial agents in an aqueous system and that are triggered to release such agents to an environment of use.

It is often desirable to provide compositions and devices that deliver or provide controlled release of one or more active ingredients/beneficial agents to an environment of use. Especially in fabric care applications, detergent compositions containing various types of active ingredients in addition to detergents are sought to improve the effectiveness of cleaning during washing and the delivery of such additional actives during post washing processes, namely rinsing, spinning and drying.

U. S. Provisional Patent Application No. 60/351,581 discloses triggered response compositions employing polyelectrolyte compositions whose polymer properties such as stability and solubility are a function of changes in one or more chemical and/or physical properties of the aqueous system in which the polyelectrolyte is dispersed. Adjusting one or more chemical and/or physical properties of the aqueous system, such as the ionic strength, trigger the polyelectrolyte to respond by destabilizing, dissolving, swelling or dispersing in to the aqueous system under relatively low ionic strength conditions while remaining stable and insoluble in an altered or separate aqueous system under relatively high ionic strength conditions. The polyelectrolyte compositions

enable the fabrication of barriers and devices that surrounds, encapsulates or forms a matrix with one or more active ingredients. The barriers and devices protect the active ingredients from premature release and then are triggered or manipulated to produce a desired release of actives via dissolution, degradation, swelling or dispersion of the polyelectrolyte barrier through alterations of one or more or a series of chemical and/or physical properties of the aqueous system.

It is desirable to improve both the stability and mechanical strength of barrier materials in contact with an aqueous system that includes detergents, surfactants and mechanical agitation, especially for fabric laundry applications. Inventors have discovered that the use of multi-stage polymer particles as ionic strength responsive barrier materials to encapsulate active ingredients and to subsequently achieve triggered release of the actives in a rinse cycle overcomes the problem of the active or beneficial agent prematurely dispersing in to the aqueous system as a result of shear induced agitation. Polyelectrolytes including multi-stage polymer particles have significantly improved wet mechanical strength in aqueous systems and have utility as barrier materials, encapsulating agents and devices for the triggered delivery/release of fabric care active ingredients and other related beneficial agents to an environment of use.

Polyelectrolytes usefully employed in the invention are multi-stage polymers including alkali soluble/swellable emulsion (ASE) polymers and hydrophobically modified alkali soluble/swellable emulsion (HASE) polymers as a first stage and at least a second stage which includes a more cross-linked ASE/HASE emulsion polymer or a non-ASE/HASE emulsion polymer. Both the first and second stage polymers incorporate carefully selected monomer compositions such that barrier materials and devices prepared from the multi-stage polyelectrolytes exhibit improved wet mechanical strength in an aqueous system and decreased swelling over a single stage emulsion polymer when exposed to high concentrations of detergents, surfactants and high shear forces induced via agitation. The improved stability and mechanical strength of the multi-stage polymers, however, does not impede the barrier from disintegrating

and destabilizing under rinsing conditions and further does not impede a triggered response device from releasing the actives into the rinsing system. Improved mechanical strength and wet strength of the barrier materials is a function of the degree of cross-linking, the glass transition temperature (T_g), the hydrophobicity of the second stage polymer, and the proportion of second stage polymers to first stage polymers.

Triggered response characteristics of the multi-stage polymers are a function of changes in one or more chemical and physical properties of both the polyelectrolyte and the aqueous system in which they are in contact with (e.g. dispersed in) as a consequence of one or more parameters including the type and amounts of acidic monomers, the degree of neutralization of the acidic monomers, the type and amounts of non-ionic vinyl surfactants and the ionic strength of the aqueous system. Inventors have further discovered that such polyelectrolytes prepared from multi-stage polymer particles form effective barrier materials for surrounding, encapsulating and/or forming a matrix with one or more active ingredients in an aqueous system and that the stability of the barrier materials can be usefully manipulated to respond to changes in one or more chemical and/or physical properties of the aqueous system in addition to ionic strength including: pH, temperature, mechanical agitation, dilution and combinations thereof. In an aqueous system such as fabric washing cycle under relatively high ionic strength conditions, the polymer compositions are sufficiently stable and form effective barriers to contain or encapsulate one or more active ingredients/beneficial agents. Exposing the compositions to an aqueous system under relatively low ionic strength conditions, such as fabric rinsing cycle, triggers instability in the compositions such that the active ingredients are rapidly dispersed in the aqueous system. The triggered response compositions of the present invention obviate the limitations to the prior art noted above and provide new compositions, devices, and processes for delivering controlled release of one or more active ingredients/beneficial agents to an environment of use.

Accordingly, there is provided a triggered response composition comprising: one or more polyelectrolytes in contact with an aqueous system that is stable and insoluble in an aqueous system at relatively high ionic strength and that exhibits one or more chemical/physical responses selected from dispersing, degrading, disintegrating, dissolving, destabilizing; wherein the chemical/physical response of the composition is triggered upon one or more ionic strength changes to the aqueous system. The polyelectrolyte comprises a polymer including (a) 70-99 weight percent of an alkali soluble/swellable emulsion polymer as a first stage; and (b) 1 to 30 weight percent of a more cross-linked ASE/HASE emulsion polymer or a non-ASE/HASE emulsion polymer as at least a second stage, wherein the improved mechanical strength and wet strength of the barrier materials is a function of the degree of cross-linking, Tg, the hydrophobicity of the second stage the polymer and the proportion of second stage emulsion polymer to the first stage emulsion polymer. The aqueous system is a fabric washing or cleaning system and wherein the chemical/physical response of the polymers is a function of changes in one or more parameters in addition to ionic strength selected from: pH, surfactant concentration level, temperature, mechanical agitation and the combinations thereof.

In one embodiment, the triggered response composition is a two-stage polymer comprising (a) 80 to 95 weight percent of an alkali soluble/swellable emulsion polymer as a first stage; and (b) 5 to 20 weight percent of a highly cross-linked emulsion polymer as a second stage

Secondly, there is provided a triggered response barrier composition comprising: one or more multi-stage polyelectrolytes in contact with an aqueous system, wherein the barrier composition surrounds, encapsulates or forms a matrix with one or more active ingredients; wherein the barrier composition is stable and insoluble in an aqueous system at relatively high ionic strength; wherein the barrier exhibits one or more chemical/physical responses selected from dispersing, degrading, disintegrating, dissolving, destabilizing, deforming, swelling; wherein the chemical/physical response of the composition is triggered

upon one or more ionic strength changes to the aqueous system; and wherein the barrier composition is capable of releasing the active ingredients to the aqueous system as a result of the triggered response.

5 There is provided a device for the triggered release of one or more active ingredients to an aqueous system comprising:

- (a) one or more active ingredients;
 - (b) one or more additives; and
 - (c) a barrier composition comprising one or more ionic strength responsive
- 10 multi-stage polyelectrolytes;

wherein the barrier composition surrounds, encapsulates or forms a matrix with one or more active ingredients; wherein the barrier composition is stable and insoluble in an aqueous system at relatively high ionic strength; wherein the barrier exhibits one or more chemical/physical responses selected

15 from dispersing, disintegrating, degrading, dissolving, destabilizing, and deforming; wherein the chemical/physical response of the composition is triggered upon one or more ionic strength changes to the aqueous system; and wherein the device is capable of releasing the active ingredients to the aqueous system as a result of the triggered response of the barrier composition.

20 There is also provided a process for triggering the release of one or more active ingredients to an aqueous system comprising the steps of:

- (a) surrounding, encapsulating or forming a matrix with one or more active ingredients with an ionic strength responsive barrier
- 25 composition prepared from a multi-stage polymer, the barrier being substantially impermeable to releasing the active ingredients to the aqueous system and remaining insoluble in the aqueous system; and
- (b) altering the ionic strength of the aqueous system;

wherein the barrier composition disperses, destabilizes, disintegrates, dissolves,

30 deforms or swells and becomes substantially permeable, thereby triggering the release of the active ingredients into the aqueous system.

The term "polyelectrolyte" as it relates to the present invention refers to a polymer or macromolecular compound in contact with an aqueous system containing a plurality of ionized and/or ionizable groups within the polymer as a result of the polymerization of one or more monomers having ionized and/or ionizable groups. The polyelectrolyte is in contact with an aqueous system including for example water, water incorporating hydrogen bonding solvents, polar solvents and organic solvents. It is contemplated that non-aqueous systems, including for example those containing solvents that can solvate ions and charged groups, are usefully employed in the present invention.

Polyelectrolytes usefully employed in the invention may contain exclusively cationic groups, may contain exclusively anionic groups or may be amphoteric, containing a combination of cationic and anionic groups. The individual ionizable components of the polyelectrolyte include weak or strong acidic groups, such as for example sulphonic, phosphonic and carboxylic groups respectively; weak or strong basic groups such as for example primary amines, secondary amines, amides, phosphines and tertiary amines respectively; and amphoteric groups such as amino acids for example. The acidic groups of the polyelectrolytes are un-neutralized, partially neutralized or completely neutralized. The basic groups of the polyelectrolytes are un-neutralized and/or un-quaternized, partially neutralized and/or quaternized or completely neutralized and/or quaternized. Suitable examples of polyelectrolytes usefully employed in the invention include poly(acidic) homopolymers, copolymers and salts thereof such as polycarboxylic acid polymers and salts thereof, alkali soluble emulsion polymers, hydrophobically modified alkali soluble emulsion polymers and polyaspartic polymers; poly(basic) homopolymers, copolymers and salts thereof, and amphoteric homopolymers, copolymers and salts thereof. Preferred polyelectrolytes include alkali soluble emulsion polymers, referred to as ASE polymers and hydrophobically modified alkali soluble emulsion polymers, referred to as HASE polymers, and polyaspartic acid polymers.

The term "triggered response" as it relates to the present invention refers to regulating, manipulating or altering one or more chemical/physical properties

of a polymer composition in contact with an aqueous system by triggering changes in or through alteration of one or more chemical/physical parameters or properties of the aqueous system. Typical polymer chemical/physical parameters of interest include for example solubility, swelling behavior, stability, porosity, degree of neutralization, polymer colligative properties, acid/base properties of polymer functional groups, and reactivity of polymer functional groups. Typical chemical/physical parameters and properties of the aqueous system in addition to ionic strength include, for example, pH, temperature, surfactant concentration, mechanical forces such as pressure, osmotic pressure, diffusion, mechanical agitation, chemical reagents capable of reacting with or neutralizing polymer functional groups, colligative properties of the aqueous system and combinations of such parameters. The inventors have discovered that the solubility, dispersibility, deformability, swellability and stability response of alkali soluble/swellable emulsion (ASE and HASE) polymers in an aqueous system can be triggered by altering or changing the ionic strength of the aqueous system; and in addition to the ionic strength, changes in pH, surfactant concentration, temperature, mechanical forces and combinations thereof.

The polymer particles usefully employed in accordance with the present invention and having a triggered response are multi-stage polymers. The term "multi-stage" polymer refers to polymers having two or more polymer stages wherein the first stage is an alkali soluble/swellable emulsion polymer and wherein at least the second or outermost stage of the polymer includes a more cross-linked alkali soluble/swellable or a non-alkali soluble/swellable emulsion polymer. The alkali soluble/swellable polymer stage includes from 50 to 99 % by weight of the polymer particle. In one embodiment, the alkali polymer stage includes from 70 to 95 % by weight of the polymer particle. The second or outermost stage of the polymer particle includes from 1 to 50 % by weight of a highly cross-linked emulsion polymer. In one embodiment, the more cross-linked stage includes from 5 to 30 % by weight of the polymer particle.

Each of the polymer stages of the polymer particles of the invention is sequentially polymerized and, as used herein, the term "stage" refers to the polymer formed during each sequence of the polymerization. Each stage is also defined as being different from the immediately proceeding and/or immediately subsequent stage. The multi-stage polymer particles are prepared by a variety of standard processes which are well known in the art including suspension, emulsion, dispersion, bulk and solution polymerization. Multi-stage polymers of the invention are prepared by emulsion polymerization as described in U. S. Patent Nos. 4,421,902; 4,427,836; and 5,451,641. Emulsion polymerization techniques used to prepare multi-staged emulsion polymer binders are well known in the art. For example, sequential emulsion polymerization processes which are believed to yield core/shell particles are described in U.S. Pat. Nos. 4,325,856; 4,654,397; 4,814,373; and 6,060,532. Other modified latex polymer compositions which are believed to contain particles incorporating multiple incompatible polymeric phases are described in U.S. Pat. No. 4,814,373.

The multi-stage polymer comprises at least one polymer stage which is alkali soluble/swellable emulsion polymer and at least one stage which comprises a highly cross-linked emulsion polymer which is alkali insoluble. The term "alkali insoluble" or "base insoluble" means that polymer is insoluble in an aqueous medium which has been adjusted with base to a pH of 5.0 or greater. The alkali insoluble polymer stage comprises 0 to 100 % by weight of one or more monoethylenically unsaturated monomers and 0 to 100 % by weight of one or more multi-functional monomers. The term "multi-functional monomers refers to (i) monomers having two or more ethylenically unsaturated groups and (ii) monomers having one or more ethylenically unsaturated groups and one or more chemically reactive functional groups.

Typical multi-functional monomers of type (i) include, but are not limited to: allyl methacrylate (ALMA), ethylene glycol dimethacrylate (EGDMA), butylene glycol dimethacrylate (BGDMA), diallyl phthalate (DAP), methylenebisacrylamide, pentaerythritol di-, tri- and tetra-acrylates, divinyl

benzene, polyethylene glycol diacrylates, bisphenol A diacrylates and combinations thereof. Typical multi-functional monomers of type (ii) include, but are not limited to: glycidyl (meth)acrylate, allyl glycidyl ether, glycidyl cinnamates, glycidyl crotonates, glycidyl itaconates, glycidyl norbornenyl ester, glycidyl norbornenyl ether and combinations thereof. In a preferred embodiment, the alkali insoluble polymer stage comprises 90 to 99.9 % by weight of one or more monoethylenically unsaturated monomers and 0.1 to 10 % by weight of one or more multi-functional monomers.

The alkali soluble polymer stage comprises one or more alkali soluble emulsion (ASE) polymers and/or hydrophobically modified alkali soluble emulsion (HASE) polymers. Alkali soluble/swellable emulsion (ASE) polymers are polyelectrolytes based on acid-containing emulsion polymers disclosed in U. S. Patent Nos. 3,035,004 and 4,384,096 (HASE polymers) and Great Britain Pat. No. 870,994. The inventors have discovered that adjusting the type and level of acid monomers and co-monomers in ASE polymers coupled with the degree of neutralization to achieve optimum charge density to afford polymers that are stable, having a low degree of swelling and insoluble in an aqueous system of relatively high ionic strength. The polymers usefully employed in the invention have varying degree of neutralization of the carboxylic acid groups ranging from partially to completely neutralized. The polymers can be characterized as incorporating an ionic strength trigger or referred to as ionic strength sensitive polymers. Changes in the ionic strength of the aqueous system to lower levels results in the a polymer that rapidly disperses, dissolves or swells to a significant extent in the aqueous system.

The ASE and HASE polymers of the present invention are typically prepared using standard emulsion polymerization techniques under acidic conditions such that the carboxylic acid groups are in protonated form to insolubilize the polymer and afford a liquid emulsion. When added as a liquid colloidal dispersion, the finely divided ASE polymer particles dissolve almost instantly upon pH adjustment. The degree of neutralization, the type and

amounts of both acidic monomers and non-ionic surfactant groups of the HASE polymers can be controlled precisely, affording ionic strength sensitive polymers whose stability, dispersibility, swell properties and solubility depend on the ionic strength of the aqueous system. The polymer compositions usefully employed in the present invention incorporate one or more trigger means, namely an ionic strength triggering condition. The ease of handling, metering, and dispersing ASE and HASE polymers, the rapid solubilization and optimization of charge density on neutralized acidic functional groups by controlled pH adjustment, and the highly desirable film forming and barrier properties make ASE and HASE polymers a most effective and efficient barrier composition for a wide variety of applications including regulated release devices for personal care and household actives, encapsulating compositions that effect the controlled release of beneficial agents and active ingredients, sensor materials and sensing devices, imaging and diagnostic agents, materials and devices for separations, molecular recognition, tracing and biological molecular conjugate assays.

Monomer Components of ASE and HASE Polymer Stage

The HASE polymer stage of this invention include three components, as disclosed in U. S. Patent No. 4,384,096: (a) 15-70 weight percent of one or more acidic monomers, (b) 15-80 weight percent of one or more non-ionic vinyl monomers, (c) 2-30 weight percent of one or more non-ionic vinyl surfactant monomers, and optionally (d) 0.01-5 weight percent of one or more polyethylenically unsaturated monomers. It has been discovered that the effectiveness of ASE and HASE polymers as ionic strength responsive compositions for triggered release is critically dependent on the following components: (i) the type and amounts of acidic monomers, (ii) the degree of neutralization of the acidic monomers, and (iii) the type and amounts of non-ionic vinyl monomers, (iv) the type and amounts of non-ionic vinyl surfactant monomers, (v) the type and amounts of polyethylenically unsaturated monomers, (vi) the pH of the aqueous system and (vii) combinations thereof.

The acid monomers provide the requisite ionic strength responsiveness and the degree of neutralization of the acidic monomers is critical in optimizing the charge density of the acidic groups. The non-ionic vinyl monomers provide an extended polymer backbone structure and added hydrophobic balance. The non-ionic vinyl surfactant monomers provide a bound surfactant. All four components contribute to preparing ionic strength sensitive polymers and barrier compositions whose stability, swell properties and solubility depend on the ionic strength of the aqueous system. Within the stated limits, the proportions of the individual monomers can be varied to achieve optimum properties for specific triggered release applications.

Acidic Monomers

The ASE and HASE polymers require 15-70 weight percent based on total monomer content of one or more acidic monomers selected from the group consisting of C₃-C₈ α,β-ethylenically unsaturated carboxylic acid monomers such as acrylic acid, methacrylic acid, maleic acid, crotonic acid, itaconic acid, fumaric acid, aconitic acid vinyl sulfonic acids and vinyl phosphonic acids, acryloxypropionic acid, methacryloxypropionic acid, monomethyl maleate, monomethyl fumarate, monomethyl itaconate and the like and combinations thereof. Acrylic acid (AA) or methacrylic acid (MAA) or a mixture thereof are preferred. Mixtures of AA or MAA with itaconic or fumaric acid are suitable and mixtures of crotonic and aconitic acid and half esters of these and other polycarboxylic acids such as maleic acid with C₁-C₄ alkanols are also suitable, particularly if used in minor amount in combination with acrylic or methacrylic acid. For most purposes, it is preferable to have at least about 15 weight percent and most preferably from about 20-50 weight percent of acidic monomers. However, polycarboxylic acid monomers and half esters can be substituted for a portion of the acrylic or methacrylic acid, e.g., about 1-15 weight percent based on total monomer content.

Non-ionic Vinyl Monomers

To provide a stable aqueous dispersion and a desirable hydrophobic:hydrophilic balance needed for the ASE and HASE polymers of the present invention requires about 15-80 weight percent of one or more co-

5 polymerizable non-ionic monomers selected from the group consisting of C_2-C_{18} α,β -ethylenically unsaturated monomers, C_1-C_8 alkyl and C_2-C_8 hydroxy alkyl esters of acrylic and methacrylic acid including ethyl acrylate, ethyl methacrylate, methyl methacrylate, 2-ethylhexyl acrylate, butyl acrylate, butyl methacrylate, 2-hydroxyethyl acrylate, 2-hydroxybutyl methacrylate; styrene,

10 vinyltoluene, t-butylstyrene, isopropylstyrene, and p-chlorostyrene; vinyl acetate, vinyl butyrate, vinyl caprolate; acrylonitrile, methacrylonitrile, butadiene, isoprene, vinyl chloride, vinylidene chloride, and the like. In practice, a mono vinyl ester such as methyl acrylate, ethyl acrylate, butyl acrylate is preferred.

15 These monomers, of course, must be co-polymerizable with the acidic monomers and vinyl surfactant monomers. Normally about 15-80 weight percent, and preferably about 20-70 weight percent of nonionic vinyl monomer, based on total weight of monomers, is used in preparing ASE polymers.

20 Non-ionic Vinyl Surfactant Monomers of HASE polymers

The third required monomer is about 0.1-30 weight percent based on total monomer content of one or more non-ionic vinyl surfactant monomers, preferably selected from the group consisting of an acrylic or methacrylic acid ester of a $C_{12}-C_{24}$ alkyl monoether of a polyalkylene glycol having at least 2 oxyalkylene units

25 therein, preferably having at least 6 to 70 oxyalkylene units. More preferred are the acrylate and methacrylate surfactant esters selected from the group consisting of: alkyl phenoxy poly(ethyleneoxy)ethyl acrylates and methacrylates; alkoxy poly(ethyleneoxy)ethyl acrylates and methacrylates; wherein ethyleneoxy unit is about 6-70. Preferable monomers may be defined by the general formula

30 $H_2C=C(R) \cdot C(O) \cdot O(CH_2CH_2O)_nR'$ wherein R is H or CH_3 , the latter being preferred, n is at least 2, and preferably has an average value of at least 6, up to 40 to 60 and even up to 70 to 100 and R' is a hydrophobic group, for example, an

alkyl group or an alkyl phenyl group having 12 to 24 carbon atoms or having an average of 12 to 24 or more carbon atoms. It is preferable to have at least about 2 weight percent and most preferably from about 2-20 weight percent of non-ionic vinyl surfactant monomers.

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These essential vinyl surfactant monomers are the acrylic or methacrylic acid esters of certain nonionic surfactant alcohols. Such surfactant esters are known in the art. For example, Junas et al. U.S. Pat. No. 3,652,497 describe the use of alkylphenoxypoly(ethyleneoxy)ethyl acrylates in preparing several other
10 polymeric surfactant thickeners. Dickstein U.S. Pat. No. 4,075,411 describes several processes for preparing such vinyl surfactant esters including the acid catalyzed condensation of commercially available nonionic polyoxyalkylene surfactant alcohols such as alkylphenoxypoly(ethyleneoxy)ethyl alcohol and block-polymeric glycols with acrylic, methacrylic, crotonic, maleic, fumaric,
15 itaconic or aconitic acid. Alternate esterification methods including alcoholysis and transesterification are also described. Other suitable vinyl surfactant esters can be prepared from monoethers of mixed or heteropolymeric ethyleneoxypropyleneoxy-butyleneoxy polyglycols such as described in Patton U.S. Pat. No. 2,786,080. Additional surfactant alcohols which can be esterified
20 for use herein are given in "McCutcheon's Detergents and Emulsifiers" 1973, North American Edition, Allured Publishing Corp., Ridgewood, N.J. 07450.

Certain of these vinyl surfactant monomer esters, i.e., those defined by the Formula are useful in preparing the HASE polymers described herein. It is
25 essential that the surfactant monomer be incorporated in the liquid emulsion product by copolymerization. Advantageously the requisite surfactant esters are prepared by the direct acid catalyzed esterification of the appropriate surfactant alcohol with an excess of the carboxylic acid monomer used as Component A. The resulting mixture with excess acid can be used directly in the copolymerization
30 provided that at least 30 percent, and preferably 50-70 percent or more, of the surfactant alcohol in the mixture is esterified. The vinyl surfactant ester can also be recovered, purified by conventional means using an appropriate inhibitor

such as hydroquinone or p-tert-butylcatechol to prevent undesired homopolymerization, and then used to prepare HASE polymers.

It has been found that the balance of acidic monomers to non-ionic monomers is an important factor in the triggered release response and performance of the resulting ASE and HASE polymers used in barrier or encapsulating compositions and delivery devices.

Optionally, the ASE and HASE polymers include a small amount of at least one polyethylenically unsaturated monomer, to provide a polymer having a network structure. One or more polyethylenically unsaturated monomers may be combined with the monomers during the polymerization process or may be added after the polymerization of monomers. Suitable examples include allyl methacrylate (ALMA), ethylene glycol dimethacrylate (EGDMA), butylene glycol dimethacrylate (BGDMA), diallyl phthalate (DAP), methylenebisacrylamide, pentaerythritol di-, tri- and tetra-acrylates, divinyl benzene, polyethylene glycol diacrylates, bisphenol A diacrylates and combinations thereof. Low levels of the polyethylenically unsaturated monomers are preferred, since levels greater than about 5% by weight tend to over cross-link the polymer or provide a polymer network structure such that their effectiveness in the invention markedly decreases. Preferred amounts of the polyethylenically unsaturated monomers range from 0.01 to 5% by weight based on the total weight of the polymer, more preferably from 0.05 to 0.5% by weight based on the total weight of the polymer.

Polymerization Conditions

The ASE and HASE polymers are conveniently prepared from the above-described monomers by conventional emulsion polymerization at an acid pH lower than about 5.0 using free-radical producing initiators, usually in an amount from 0.01 percent to 3 percent based on the weight of the monomers. The free-radical producing initiators conveniently are peroxygen compounds especially inorganic persulfate compounds such as ammonium persulfate, potassium persulfate, sodium persulfate; peroxides such as hydrogen peroxide;

organic hydroperoxides, for example, cumene hydroperoxide, t-butyl hydroperoxide; organic peroxides, for example, benzoyl peroxide, acetyl peroxide, lauroyl peroxide, peracetic acid, and perbenzoic acid (sometimes activated by a water-soluble reducing agent such as ferrous compound or sodium bisulfite); as
5 well as other free-radical producing materials such as 2,2'-azobisisobutyronitrile.

The process for preparing ASE polymers of this invention includes a free radical thermal initiator or redox initiator system under emulsion polymerization conditions. Monomers suitable for the novel process include
10 hydrophobic and hydrophilic monoethylenically unsaturated monomers which can be subjected to free radical polymerization in a straight forward manner. "Hydrophilic" refers to monoethylenically unsaturated monomers which have high water solubility under the conditions of emulsion polymerization, as described in U.S. Patent No. 4,880,842. "Hydrophobic" refers to
15 monoethylenically unsaturated monomers which have low water solubility under the conditions of emulsion polymerization, as described in U.S. Patent No. 5,521,266.

Suitable thermal initiators include, for example, hydrogen peroxide,
20 peroxy acid salts, peroxodisulfuric acid and its salts, peroxy ester salts, ammonium and alkali metal peroxide salts, perborate salts and persulfate salts, dibenzoyl peroxide, t-butyl peroxide, lauryl peroxide, 2, 2'-azo bis(isobutyronitrile) (AIBN), alkyl hydroperoxides such as tert-butyl hydroperoxide, tert-amyl hydroperoxide, pinene hydroperoxide and cumyl
25 hydroperoxide, t-butyl peroxyneodecanoate, t-butyl Peroxypivalate and combinations thereof.

Suitable oxidants of the redox initiator system include water-soluble oxidizing compounds such as, for example, hydrogen peroxide, peroxy acid salts,
30 peroxodisulfuric acid and its salts, peroxy ester salts, ammonium and alkali metal peroxide salts, perborate salts and persulfate salts. Suitable oxidants of a redox initiator system also include water-insoluble oxidizing compounds such as,

for example, dibenzoyl peroxide, t-butyl peroxide, lauryl peroxide, 2, 2'-azo bis(isobutyronitrile) (AIBN), alkyl hydroperoxides such as tert-butyl hydroperoxide, tert-amyl hydroperoxide, pinene hydroperoxide and cumyl hydroperoxide, t-butyl peroxyneodecanoate, and t-butyl peroxy-pivalate.

5 Compounds which donate oxygen with free radical formation and are not peroxides, such as alkali metal chlorates and perchlorates, transition metal oxide compounds such as potassium permanganate, manganese dioxide and lead oxide and organic compounds such as iodobenzene, may be usefully employed in accordance with the invention as oxidants. The term "water-insoluble" oxidants
10 means oxidizing compounds having a water solubility of less than 20 % by weight in water at 25° C. Peroxides, hydroperoxides and mixtures thereof are preferred and tert-butyl hydroperoxide is most preferred. Typical levels of oxidant range from 0.01% to 3.0%, preferably from 0.02% to 1.0% and more preferably from 0.05% to 0.5% by weight, based on the weight of the monomer used.

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Suitable reductants of the redox initiator system include reducing compounds such as, for example, sulfur compounds with a low oxidation state such as sulfites, hydrogen sulfites, alkali metal bisulfites, ketone adducts of bisulfites such as acetone bisulfite, alkali metal disulfites, metabisulfites and its
20 salts, thiosulfates, formaldehyde sulfoxylates and its salts, reducing nitrogen compounds such as hydroxylamine, hydroxylamine hydrosulfate and hydroxylammonium salts, polyamines and reducing sugars such as sorbose, fructose, glucose, lactose and derivatives thereof, enediols such as ascorbic acid and isoascorbic acid, sulfinic acids, hydroxy alkyl sulfinic acids such as hydroxy
25 methyl sulfinic acid and 2-hydroxy-2-sulfinacetic acid and its salts, formadinesulfinic acid and its salts, alkyl sulfinic acids such as propyl sulfinic acid and isopropyl sulfinic acid, aryl sulfinic acids such as phenyl sulfinic acid. The term "salts" includes for example sodium, potassium, ammonium and zinc ions. Sodium formaldehyde sulfoxylate, also known as SSF, is preferred. Typical
30 levels of reductant range from 0.01% to 3.0%, preferably from 0.01% to 0.5% and more preferably from 0.025% to 0.25% by weight, based on the weight of the monomer used.

The metal promoter complex of the redox initiator system includes a water-soluble catalytic metal compound in the form of a salt and a chelating ligand. Suitable metal compounds include metal salts such as, for example iron(II, III) salts such as iron sulfate, iron nitrate, iron acetate and iron chloride, cobalt(II) salts, copper(I, II) salts, chromium (II) salts, manganese salts, nickel(II) salts, vanadium salts such as vanadium(III) chloride, vanadium(IV) sulfate and vanadium(V) chloride, molybdenum salts, rhodium salts and cerium(IV) salts. It is preferred that metal compounds are in the form of hydrated metal salts. Typical levels of catalytic metal salts used in accordance with the invention range from 0.01 ppm to 25 ppm. Mixtures of two or more catalytic metal salts may also be usefully employed in accordance with the invention.

Metal complexes that promote the redox cycle in a redox initiator system must not only be soluble, but must have suitable oxidation and reduction potentials. Generally stated, the oxidant must be able to oxidize the low oxidation state of metal promoter complex (e.g. $\text{Fe(II)} \rightarrow \text{Fe(III)}$) and conversely, the reductant must be able to reduce the high oxidation state of the metal promoter catalyst (e.g. $\text{Fe(III)} \rightarrow \text{Fe(II)}$). The choice of a particular oxidant and reductant usefully employed in a redox initiator system for preparing aqueous emulsion polymers from two or more ethylenically unsaturated monomers depends on the redox potentials of the metal salts. In addition, the ratio of oxidant to reductant ranges from 0.1:1.0 to 1.0:0.1, depending on the redox potential of the metal salt employed. For the efficient reduction of monomer levels in an aqueous polymer dispersion prepared from one or more ethylenically unsaturated monomers, it is preferred that the chelating ligand used in combination with the soluble metal salt is a multidentate aminocarboxylate ligand having fewer than six groups available for coordination to the metal salt.

Oxidant and reductant are typically added to the reaction mixture in separate streams or as a single shot, preferably concurrently with the monomer mixture. The reaction temperature is maintained at a temperature lower than

100 °C throughout the course of the reaction. Preferred is a reaction temperature between 30 °C and 85 °C, preferably below 60°C. The monomer mixture may be added neat or as an emulsion in water. The monomer mixture may be added in one or more additions or continuously, linearly or not, over the
5 reaction period , or combinations thereof. The type and amount of redox initiator systems may be the same or different in the various stages of the emulsion polymerization.

Optionally, a chain transfer agent and an additional emulsifier can be
10 used. Representative chain transfer agents are carbon tetrachloride, bromoform, bromotrichloromethane, long chain alkyl mercaptans and thioesters such as n-dodecyl mercaptan, t-dodecyl mercaptan, octyl mercaptan, tetradecyl mercaptan, hexadecyl mercaptan, butyl thioglycolate, isooctyl thioglycolate, and dodecyl thioglycolate. The chain transfer agents are used in amounts up to about 10
15 parts per 100 parts of polymerizable monomers.

Often at least one anionic emulsifier is included in the polymerization charge and one or more of the known nonionic emulsifiers may also be present. Examples of anionic emulsifiers are the alkali metal alkyl aryl sulfonates, the
20 alkali metal alkyl sulfates and the sulfonated alkyl esters. Specific examples of these well-known emulsifiers are sodium dodecylbenzenesulfonate, sodium disecndary-butyl naphthalene sulfonate, sodium lauryl sulfate, disodium dodecyldiphenyl ether disulfonate, disodium n-octadecylsulfosuccinamate and sodium dioctylsulfosuccinate.

25
Optionally, other ingredients well known in the emulsion polymerization art may be included such as chelating agents, buffering agents, inorganic salts and pH adjusting agents.

30 Polymerization at an acid pH lower than about 5.0 permits direct preparation of an aqueous colloidal dispersion with relatively high solids content without problems of undue viscosity and coagulant formation. The

polymerization is carried out batch-wise, stepwise or continuously with batch and/or continuous addition of the monomers in a conventional manner.

The required monomers can be co-polymerized in such proportions, and the resulting emulsion polymers can be physically blended, to give products with the desired balance of properties for specific applications. Thus, by varying the monomers and their proportions, emulsion polymers having optimum properties for particular triggered response applications can be designed.

In practice it is normally desirable to co-polymerize about 15-60 weight percent based on total monomers, preferably about 20-40 weight percent of one or more acidic monomers, about 15-80 weight percent, preferably about 40-70 weight percent, of one or more non-ionic vinyl monomers and about 1-30 weight percent, preferably about 2-20 weight percent, of one or more non-ionic vinyl surfactant ester monomers. Particularly effective liquid emulsion polymer electrolytes are obtained by copolymerization of a total of about 20-50 weight percent of acrylic acid and methacrylic acid, about 40-70 weight percent of ethyl acrylate, and about 2-12 weight percent of the methacrylic ester of a C_{12} - C_{24} alkoxypoly(ethyleneoxy) ethyl alcohol.

In general, the ASE and HASE copolymer dispersions obtained have a solids content ranging from 20 to 50% by weight and the copolymer has a weight average molecular weight of about 200,000 to 10,000,000, when no polyethylenically unsaturated monomer is incorporated into the polymer, as determined by gel permeation chromatography (GPC). A chain transfer agent may be used to obtain weight average molecular weights down to 30,000 or lower.

The ASE and HASE copolymer products prepared by emulsion polymerization at an acid pH are in the form of stable aqueous colloidal dispersions usually with a typical milky latex appearance. Such a liquid

emulsion contains the copolymer dispersed as discrete particles having average particle diameters of about 500-3000 Å, as measured by light scattering.

In the form of a stable, aqueous colloidal dispersion at an acid pH of about 2.5-5.0 the ASE and HASE copolymers are particularly useful and have desirable film forming properties. Such aqueous dispersion may contain about 10-50 weight percent of polymer solids yet be of relatively low viscosity. Thus it is readily metered and blended with aqueous product systems. However, the dispersion is ionic strength responsive. When the ionic strength of the polymer dispersion is adjusted by addition of a base such as ammonia, an amine or a non-volatile inorganic base such as sodium hydroxide, potassium carbonate or the like, the aqueous mixture becomes translucent or transparent as the polymer dissolves at least partially in the aqueous phase with a concurrent increase in viscosity. This neutralization can occur *in-situ* when the liquid emulsion polymer is blended with an aqueous solution containing a suitable base. Or if desired for a given application, pH adjustment by partial or complete neutralization can be carried out before or after blending the liquid emulsion polymer with an aqueous product.

The glass transition temperature ("Tg") of the ASE and HASE polymers typically range from -60 °C to 150 °C, preferably from -20 °C to 50 °C, the monomers and amounts of the monomers selected to achieve the desired polymer Tg range are well known in the art. Tgs used herein are those calculated by using the Fox equation (T.G. Fox, Bull. Am. Physics Soc., Volume 1, Issue No. 3, page 123(1956)). that is, for calculating the Tg of a copolymer of monomers M1 and M2,

$$1/Tg(calc.) = w(M1)/Tg(M1) + w(M2)/Tg(M2) , \text{ wherein}$$

Tg(calc.) is the glass transition temperature calculated for the copolymer

w(M1) is the weight fraction of monomer M1 in the copolymer

w(M2) is the weight fraction of monomer M2 in the copolymer

Tg(M1) is the glass transition temperature of the homopolymer of M1

Tg(M2) is the glass transition temperature of the homopolymer of M2,

All temperatures being in °K. The glass transition temperatures of homopolymers may be found, for example, in "Polymer Handbook", edited by J. Brandrup and E.H. Immergut, Interscience Publishers.

5 The term "liquid emulsion polymer" as applied to the ASE and HASE polymers means the polymer was prepared by emulsion polymerization even though the polymer per se may be (and generally is) a solid at room temperature but is a "liquid" emulsion polymer because it is in the form of a liquid dispersion.

10 The multi-polymers of this invention are advantageous for use as barrier compositions that surround, encapsulate and/or form a matrix with one or more active ingredients/beneficial agents. Two or more multi-stage polymers may be used, if desired. Of course multi-stage polymers that incorporate HASE polymers are preferably film-forming at temperatures below about 25° C., either
15 inherently or through the use of plasticizers. It has been discovered that such multi-stage polymers form effective barrier materials for surrounding, encapsulating and/or forming a matrix with one or more active ingredients immersed in an aqueous system, such that the stability of the barrier materials changes by altering the ionic strength; and in addition to ionic strength by
20 altering: pH, surfactant concentration, temperature, mechanical forces and the combinations thereof the aqueous system. In an aqueous system under certain ionic strength conditions the materials are stable, forming effective barriers to contain or encapsulate one or more actives. Exposing the materials to a subsequent aqueous system whose ionic strength has been changed, depending
25 on the type of triggered response composition(s) employed, triggers instability in the materials such that the active ingredients are rapidly dispersed in the aqueous system.

Barrier compositions prepared from one or more multi-stage polymers
30 form impermeable membranes that surround, encapsulate and/or form a matrix with one or more active ingredients, providing sufficient structural support while inhibiting the release of the beneficial agent prior to the ionic strength triggered

dissolution of the barrier of the device. Aqueous system refers to any fluid or solution containing water as the principal liquid component (e.g. solutions of organic or inorganic substances particularly electrolytes, mixtures of substance in water and physiological fluids). Typically the barrier composition totally surrounds, encapsulates and/or forms a matrix with the beneficial agent/active ingredient. One or more additives may be combined with the multi-stage polymers to prepare a composite barrier to totally surround, encapsulate and/or form a matrix with the beneficial agent if desired. The barrier and composite barrier materials have a combination of thickness and mechanical strength so that they are disrupted by the triggered response of the multi-stage polymers (triggered response compositions) thus releasing the beneficial agent. Preferably the barriers are 0.1 μm to 1 mm in thickness. Preferably the barriers are 10 μm to 300 μm in thickness for personal care and cleaning applications. The barrier may be a coating, a thin film, a dense film, a composite barrier, a container, a capsule and/or matrix beads.

Typically, a barrier composite is composed of the triggered response polymers and copolymers, polymer blends, biopolymers, and any other naturally occurring and synthetic material, although appropriately treated inorganic materials such as ceramics, metals or glasses may be used. The following is a preferred listing of components and additives that can be incorporated into the barrier material and device of the present invention.

Cellulose esters such as cellulose acetate, cellulose acetate acetoacetate, cellulose acetate benzoate, cellulose acetate butylsulfonate, cellulose acetate butyrate, cellulose acetate butyrate sulfate, cellulose acetate butyrate valerate, cellulose acetate caprate, cellulose acetate caproate, cellulose acetate caprylate, cellulose acetate carboxymethoxypropionate, cellulose acetate chloroacetate, cellulose acetate dimethaminoacetate, cellulose acetate dimethylaminoacetate, cellulose acetate dimethylsulfamate, cellulose acetate dipalmitate, cellulose acetate dipropylsulfamate, cellulose acetate ethoxyacetate, cellulose acetate ethyl carbamate, cellulose acetate ethyl carbonate, cellulose acetate ethyl

oxalate, cellulose acetate furoate, cellulose acetate heptanoate, cellulose acetate heptylate, cellulose acetate isobutyrate, cellulose acetate laurate, cellulose acetate methacrylate, cellulose acetate methoxyacetate, cellulose acetate methylcarbamate, cellulose acetate methylsulfonate, cellulose acetate myristate,

5 cellulose acetate octanoate, cellulose acetate palmitate, cellulose acetate phthalate, cellulose acetate propionate, cellulose acetate propionate sulfate, cellulose acetate propionate valerate, cellulose acetate p-toluene sulfonate, cellulose acetate succinate, cellulose acetate sulfate, cellulose acetate trimellitate, cellulose acetate tripropionate, cellulose acetate valerate, cellulose

10 benzoate, cellulose butyrate naphylate, cellulose butyrate, cellulose chlorobenzoate, cellulose cyanoacetates, cellulose dicaprylate, cellulose dioctanoate, cellulose dipentenate, cellulose dipentenate, cellulose formate, cellulose methacrylates, cellulose methoxybenzoate, cellulose nitrate, cellulose nitrobenzoate, cellulose phosphate (sodium salt), cellulose phosphinates,

15 cellulose phosphites, cellulose phosphonates, cellulose propionate, cellulose propionate crotonate, cellulose propionate isobutyrate, cellulose propionate succinate, cellulose stearate, cellulose sulfate (sodium salt), cellulose triacetate, cellulose tricaprylate, cellulose triformate, cellulose triheptanoate, cellulose triheptylate, cellulose trilaurate, cellulose trimyristate, cellulose trinitrate,

20 cellulose trioctanoate, cellulose tripalmitate, cellulose tripropionate, cellulose trisuccinate, cellulose trivalerate, cellulose valerate palmitate and combinations thereof. Cellulose ethers such as 2-hydroxybutyl methyl cellulose, 2-hydroxyethyl cellulose, 2-hydroxyethyl ethyl cellulose, 2-hydroxyethyl methyl cellulose, 2-hydroxypropyl cellulose, 2-hydroxypropyl methyl cellulose,

25 dimethoxyethyl cellulose acetate, ethyl 2-hydroxyethyl cellulose, ethyl cellulose, ethyl cellulose sulfate, ethylcellulose dimethylsulfamate, methyl cellulose, methyl cellulose acetate, methylcyanoethyl cellulose, sodium carboxymethyl 2-hydroxyethyl cellulose, sodium carboxymethyl cellulose. Polycarbonates. Polyurethanes. Polyvinyl acetates. Polyvinyl alcohols. Polyesters. Polysiloxanes

30 such as poly(dimethylsiloxane) and Polyaminoacids such as polyaspartic acid. Polyacrylic acid derivatives such as polyacrylates, polymethyl methacrylate, poly(acrylic acid) higher alkyl esters, poly(ethylmethacrylate), poly(hexadecyl

methacrylate-co-methylmethacrylate), poly(methylacrylate-co-styrene), poly(n-butyl methacrylate), poly(n-butyl-acrylate), poly(cyclododecyl acrylate), poly(benzyl acrylate), poly(butylacrylate), poly(secbutylacrylate), poly(hexyl acrylate), poly(octyl acrylate), poly(decyl acrylate), poly(dodecyl acrylate), poly(2-
 5 methyl butyl acrylate), poly(adamantyl methacrylate), poly(benzyl methacrylate), poly(butyl methacrylate), poly(2-ethylhexyl methacrylate), poly(octyl methacrylate), acrylic resins. Polyethers such as poly(octyloxyethylene), poly(oxyphenylethylene), poly(oxypropylene), poly(pentyloxyethylene), poly(phenoxy styrene), poly(secbutoxyethylene),
 10 poly(tert-butoxyethylene), copolymers thereof and polymer blends thereof.

Typical naturally occurring materials include: insect and animal waxes such as chinese insect wax, beeswax, spermaceti, fats and wool wax; vegetable waxes such as bamboo leaf wax, candelilla wax, carnauba wax, Japan wax,
 15 ouricury wax, Jojoba wax, bayberry wax, Douglas-Fir wax, cotton wax, cranberry wax, cape berry wax, rice-bran wax, castor wax, indian corn wax, hydrogenated vegetable oils (e.g., castor, palm, cottonseed, soybean), sorghum grain wax, Spanish moss wax, sugarcane wax, caranda wax, bleached wax, Esparto wax, flax wax, Madagascar wax, orange peel wax, shellac wax, sisal hemp wax and
 20 rice wax; mineral waxes such as Montan wax, peat waxes, petroleum wax, petroleum ceresin, ozokerite wax, microcrystalline wax and paraffins; and synthetic waxes such as polyethylene wax, Fischer-Tropsch wax, chemically modified hydrocarbon waxes including poly(ethyleneglycolated) waxes and cetyl esters wax.

25

In one embodiment, the ionic strength trigger is an ionic strength sensitive barrier composition surrounding the ingredients, the barrier substantially impermeable to releasing the active ingredients to the aqueous system and remaining insoluble in the aqueous system at relatively high ionic
 30 strength (for example, equivalent to 0.01 M sodium carbonate or greater), the barrier becoming soluble in an aqueous system at relatively lower ionic strength

(for example, equivalent to less than 0.001 M sodium carbonate) and effecting the rapid release of the active ingredients.

The triggered response composition in the barrier material or the device is usefully employed in the invention in form of, for example, a film, a coating, a tablet, a container, a packet, capsule, pellet, sachet, matrix beads, and encapsulated polymer granules. The ionic strength responsive trigger means is provided in a capsule or tablet by for example bonding, encasing, friction fitting, partially encasing the barrier material, for example, either as an adhesive, joining portions of the barrier, as an outer coating, or forming encapsulated particles and co-granulated particles together to form the capsule or tablet. The ionic strength responsive trigger means in the aqueous system causes bursting of the device followed by release of one or more beneficial agents/active ingredients.

Optionally, the ionic strength responsive barrier materials are trigger response polymer blends or they are blended with an inert non-dissolving material. By inert is meant a material that is not substantially affected by a change in ionic strength and/or other parameters in the triggering range. By altering the proportion of a ionic strength responsive material to one or more inert non-dissolving materials, the time lag subsequent to triggering and prior to release may be controlled. The inert non-dissolving material is added to further provide mechanical strength and stability to the barrier material or device during use (for example, after the polymer and barrier swells) or storage. Typical inert non-dissolving material usefully employed in the invention is listed the materials described as additives to the barrier material or device. Preferably, the inert material is selected from the list of additives given above.

The term beneficial agent refers to substances for which it is desirable and/or advantageous to triggered delivery into an environment of use. Beneficial agents include those agents in the form of a gas, solid or liquid state.

The term beneficial agent refers to substances for which it is desirable and/or advantageous to control delivery into an environment of use. Examples of such substances include: detergent additives and cleaning additives including, for example, fabric softeners, fabric softener formulations, cationic, anionic, amphoteric and non-ionic surfactants, scale controllers, anti-foam agents, buffers, amphoteric additives, builders, bleaches, organic additives, inorganic additives, whiteners, dyestuffs, stain removers, water hardness agents, reductants, oxidants, optical brighteners, UV protective agents, wrinkle reducing agents, gray-inhibitors, soil repellants, oil-absorbing polymers, waterproofing polymers, active-retaining polymers, redeposition agents, anti-redeposition agents, polymers which inhibit the formation of soil and oily materials, detergent additive formulations, biocidal compositions and formulations, antimicrobial compositions and formulations, pharmaceutical compositions and formulations, activating agents, stabilizing agents, polymers with special detergent properties such as co-builders and anti-redeposition agents, pH controlling agents, enzymes, enzyme inhibitors, disinfectants, personal care agents, water softening agents, absorbants, flavors and fragrances. Typical examples of each are described in International publication No. WO 00/17311, U. S. Patent Application Publication No. 2001/0031714 A1 and U. S. Patent No. 5,358,502.

Although any mixture of the above ingredients may be used that satisfactorily delivers the beneficial agent, typically the ionic strength-trigger means is 0.01% to 50% by weight of the device and the barrier including ionic strength-trigger means is typically 1% to 30% of the device. Preferably the ionic strength-trigger means is 0.1% to 20% of the device and the membrane, including ionic strength-trigger means, is 1% to 20% of the device. The amount of beneficial agent is the amount that is sufficient to achieve the desired effect (e.g., cleaning effect, softening effect personal care effect, and combinations thereof). The remainder weight can be made up of any desired formulation ingredients (described above) and other additives.

The devices of the invention preferably contain a solid beneficial core or a liquid beneficial core. Optionally, the devices of this invention can also be administered within a capsule comprising a water-soluble wall. For example, the devices can be manufactured to be of suitable size for inclusion either singularly or multiply within a gelatin capsule such that when the capsule dissolves the device(s) are released into the environment of use. While the devices to be included within a capsule can be of a variety of shapes, a preferred shape for such devices is spherical or substantially spherical. The exact number and size of such devices can and will be determined according to a variety of well known factors. For example, the environment of use, the beneficial agent or agents, the amount of beneficial agent and the rate of release are all factors to be considered in determining the size, shape, and number of devices to be included in such capsules as well as the composition of the capsule.

The devices of this invention having the above described desired characteristics may be made using the above described materials using the following processes and other conventional methods.

Capsule formulations may be prepared by forming a cap and body of the above-described polymers. In a conventional fashion, the triggered response polymers may be molded into the desired shapes and sintered or dip-coated (in a similar fashion to the way hard gelatin capsules are made). Preferably they are prepared by conventional coating techniques including, for example, spray coating, Wurster coating and pan coating. Alternatively, hard gelatin capsules may be coated with the barrier coating. These capsule bodies and caps are then filled with the beneficial agent in the form of a gas, liquid or solid and other excipients (e.g., osmagent, swellable component) using standard capsule filling techniques. Then the capsule is sealed with the desired ionic strength-responsive material and assembled. This may be performed using conventional capsule-sealing equipment.

Tablets may be prepared using conventional processes and conventional tableting and tablet-coating equipment. The tablet cores can be made by direct compression of the beneficial agent and other desired excipients (e.g., osmagent swellable material) or other common tableting methods. To minimize incompatibilities or provide a suitable substrate for the barrier coating, the tablets may first be coated with a water-soluble pre-coat. The pre-coat may consist of sugars, salts, soluble cellulose derivatives or other water-soluble materials.

The tablet cores are coated with either a dense triggered response barrier material or composite using conventional coating techniques. These films can be applied using conventional equipment such as fluid-bed coaters, pan-coaters, Wurster coaters, spray-dryers or by dip-coating.

In a preferred embodiment, the barrier composition is stable and insoluble in an aqueous system at relatively high ionic strength; wherein the barrier exhibits one or more chemical/physical responses selected from dispersing, disintegrating, dissolving, destabilizing, deforming, swelling, softening, flowing and combinations thereof; wherein the chemical/physical response of the composition is triggered upon one or more ionic strength changes to the aqueous system; wherein the device is capable of releasing the active ingredients to the aqueous system as a result of the triggered response of the barrier composition; wherein the device is prepared using coating technology selected from the group consisting of fluid bed spray coating, Wurster coating, Pan coating and co-extrusion, coacervation, spray drying and spray chilling; and optionally, wherein one or more beneficial liquid ingredients are co-granulated with one or more solid active ingredients in the form of solid granules, pellets, tablets, encapsulated granules, sachets, matrix beads and capsules.

One or more layers or coatings of an ionic strength responsive material is applied over on tablet cores. The coatings may be applied using standard coating methods analogous to those described to apply the barrier coating.

Beads, granules or multiple particulates may be prepared by analogous methods to those used to prepare tablets.

5 Barrier compositions prepared from one or more multi-stage polymers form impermeable barriers that surround, encapsulate and/or form a matrix with one or more active ingredients, providing sufficient structural support while inhibiting the release of the beneficial agent prior to the triggered dissolution or dispersion of the barriers of the device. Aqueous system refers to but is not
10 limited to a solution containing water as the principal liquid component including for example aqueous solutions of organic solvents, inorganic substances particularly electrolytes and surfactant mixtures of substance in water. Typically the barrier composition totally surrounds, encapsulates or forms a matrix with the beneficial agent/active ingredient or forms an
15 impermeable matrix of the barrier composition and the beneficial agent/active ingredient. The impermeable barrier membrane material has a combination of thickness and mechanical strength so that it will be sufficiently stable at predetermined system including but not limited to a heavy duty liquid (HDL) formulation or fabric laundry wash cycle and will rapidly disrupt and release the
20 beneficial ingredients once the desired triggered release environment has been generated. Preferably the impermeable barrier membrane is 5 μm to 300 μm in thickness for household and personal care applications, such as fabric care laundry application. The impermeable barrier membrane may be a dense film, a composite membrane, asymmetric in structure and the like. The preferred
25 particle size of the impermeable matrix beads of the barrier composition and the beneficial agent/active ingredient 20 to 5000 μm . Typically the device of the barrier composition material and the beneficial ingredients is composed of emulsion polymers and personal care and household care actives including but not limited to fabric care actives, personal care actives and fragrance.

30

The selected group of multi-stage polymers in any structural form may be used as the ionic strength trigger means; or in addition to an ionic strength

trigger means, a pH, surfactant concentration level, temperature, mechanical agitation and combinations thereof, trigger means that maintains the integrity of the device until triggered by a solution of the desired trigger conditions. The trigger device may be for example an impermeable dense coating membrane or an impermeable matrix. Preferably, the trigger device provides sufficient structural support and is, preferably, impermeable to water which inhibits the core from contacting with the aqueous system, and releasing the beneficial agent until triggered. Typically the trigger device is selected from a group of multi-stage polymers to form barrier compositions for surrounding, encapsulating and/or forming a matrix with the ingredients, the barrier substantially impermeable to releasing the active ingredients to the aqueous system and remaining insoluble in the aqueous system at a predetermined conditions, the barrier becoming solubilized, swelled, dispersed, deformed and/or disintegrated in an aqueous system when the ionic strength changes; and in addition to ionic strength changes, changes in pH, temperature, surfactant concentration levels, mechanical forces and combinations thereof, effecting the rapid release of the active ingredients.

Typically the barrier materials are insoluble solids in an aqueous system including but not limited to fabric laundry wash cycle, and then they dissolve (or degrade and dissolve) when the ionic strength changes; and in addition to ionic strength changes, changes in pH, temperature, surfactant concentration levels, mechanical forces and the combinations of thereof, in the system.

The devices of this invention having the above described desired characteristics may be made using the above described materials using the following processes and other conventional techniques and methods. Conventional techniques for preparing delivery devices include, for example, those disclosed in U. S. Patent No. 5,358,502.

In one preferred embodiment of the present invention, one or more beneficial ingredients are encapsulated with impermeable membranes of one or

more barrier compositions via conventional coating technology, including but not limited to fluid bed spray coating, Wurster coating, Pan coating, etc. The beneficial ingredients in liquid states can be co-granulated with other solid form active ingredients to form solid granules or tablets prior to coating process or it
5 can be incorporated along or else together with other active ingredients into a capsule made from a water soluble polymer such as, for example, gelatin. A filled gelatin capsule of this kind of beneficial ingredients is then provided with the coating comprising of barrier compositions. The coating may be made sufficiently thick so that it will be sufficiently stable in wash cycle and rapidly
10 dispersed to release beneficial ingredients in rinse cycle.

In order to ensure that the coating of the barrier compositions does not dissolve in the earlier steps of the washing or cleaning operation, for example, at the beginning of the main wash cycle in the case of machine laundry washing,
15 the stability of the barrier compositions membrane can be controlled by adjusting the degree of neutralization of the barrier compositions so that it will be insoluble at the early beginning of the wash cycle when detergent has not dissolved, then upon neutralization by the aqueous system after the dissolution of detergent, the barrier membrane will remain stable in wash cycle and rapidly
20 dissolved or dispersed in rinse cycle.

In another embodiment of the present invention, one or more beneficial ingredients are encapsulated with impermeable membranes of one or more barrier compositions or an impermeable matrix of one or more beneficial
25 ingredients and one or more barrier compositions via emulsion polymerization, suspension polymerization, and micro-suspension polymerization. Depending on which polymerization process is employed, the particle size of the final encapsulated particles or matrix particles is between 0.01 to 1000 μm .

30 In another embodiment of the present invention, one or more beneficial ingredients are encapsulated with one or more barrier compositions to form polymeric matrix beads. The matrix beads have the same actives in the cores as

are described above and surrounded by a solid polymer protective shell formed during the solidification process by either spray drying or spray chilling or by precipitating with inorganic salt solution such as CaCl_2 or Na_2SO_4 . Likewise the beads are preferably about 10 to 5000 μm big. The matrix beads made of polymer barrier compositions and beneficial ingredients contain 5 to 80% polymer barrier composition, 5 to 75% beneficial ingredients and 0 to 10% aids including surfactants. Preferably, the matrix beads should contain 5 to 50% ASE barrier polymers, 20 to 75% beneficial ingredients and 0 to 10% aids including surfactants.

The device shape and dimensions can vary based on the particular application (e.g., tablets, beads or capsules). The shape and size may also vary depending on the application so that for example the tablet is suitable depending on the quantity and rate of beneficial agent releasing which vary based on the application. Preferably, the tablet is 0.5 to 20 mm in diameter and the beads are 5 μm to 5 mm in diameter. However, typical device dimensions range from about 1 cm to about 2.5 cm in length and about 0.3 cm to about 1 cm in diameter for personal care and household applications. For other applications, such as flavors, fragrances, and other active ingredients for household and personal care applications, shapes and sizes will be determined by the method of use and may be different from those listed above.

It should be understood that the invention is not limited to the particular embodiments shown and described herein, but that various changes and modifications may be made without departing from the spirit and scope hereof as defined by the following claims. The invention is further disclosed and illustrated in the following examples.

EXAMPLE 1

Preparation of Multi-Staged Emulsion Polymer

Into a 5 liter, four-neck, round-bottomed flask ("kettle") equipped with a stirrer, thermometer, and reflux condenser was charged 1242.2 g. deionized water ("DI water") and 27.3 g. of a 28% solution of sodium lauryl sulfate, which was then heated to 60° C. in a nitrogen atmosphere. With the kettle water at 60° C. the following materials were charged to the kettle: 94 g. of monomer emulsion (ME), 14 g. of 0.15% ferrous sulfate heptahydrate, a solution of 0.43 g. of ammonium persulfate in 80.7 g. DI water, and a solution of 0.43 g. of Lykopen (sodium hydrosulfite) in 81.0 g. DI water. Five minutes after the addition of the ingredients, feeding of the remaining ME, a solution of 1.05 g. ammonium persulfate in 229.8 g. DI water and 1.07 g. sodium metabisulfite in 229.8 g. DI water were begun and carried over a period of 60 minutes at a kettle temperature of 59-61° C., a temperature maintained by cooling as required. When the ME feed and a 124 g. DI water rinse, the ammonium persulfate feed, and the Lykopen feed were completed, the batch was held at 60° C. for about 25 minutes and 100 g. of stage two monomers was added to the kettle. After the temperature was held at 60° C. for another 15 minutes, the following solutions: 0.6 g. t-butyl hydroperoxide (70% active) in 2.48 g. DI water and 0.3 g. isoascorbic acid in 62.1 g. DI water were added. About 40 minutes later with the temperature still at 60° C., 62.1 g. DI water was added and the reaction mixture was then allowed to cool to 45° C. and 2.9 g. t-butyl hydroperoxide (70% active) in 146.6 g. DI water and a solution of 1.5 g. isoascorbic acid in 62.1 g. DI water were added over a period of 20 minutes at 45° C. The temperature of the batch was held at 45° C. for another 15 minutes and then allowed to cool to ambient temperature and was filtered yielding a product with 22.6% solids, pH=2.7.

TABLE 1.1

Monomer Emulsion (ME) for Stage 1 in Sample 1 Preparation

5

DI water 931.2 g.

Sodium lauryl sulfate (28% solution) 27.3 g.

VSM-1* 128.6

Ethyl acrylate 540 g.

10

Methacrylic acid 64.3 g.

Acrylic acid 180 g.

Diallyl phthalate 1.8 g.

DI water 931.2 g.

15

*VSM-1[®] is a Rohm and Haas surfactant monomer, cetyl-stearyl (EO)₂₀ methacrylate supplied as 70active/20 methacrylic acid/10 water.

TABLE 1.2

20

Monomer Emulsion for Stage 2 in Sample 1 Preparation

25

Methyl methacrylate 95 g.

Allyl methacrylate 5 g.

30

35

40

Composition of the Multistage Polymers are shown in Table 1.3.

TABLE 1.3

Polymer	First Stage Composition (by weight)	Second Stage Composition (by weight)	1 st Stage to 2 nd Stage Weight Ratio
1	10 VSM-1 (a.i.)/60 EA/ 20 AA/10 MAA/0.2 DAP	95 MMA/5 ALMA	90/10
2	"	90 MMA/10 BGDA	90/10
3	"	50 MMA/40 MAA/10 DAP	80/20
4	"	100 MMA	94/6
5	10 VSM-1 (a.i.)/60 EA/ 20 AA/10 MAA	95 MMA/5 ALMA	90/10

NOTES:

EA ethyl acrylate

AA acrylic acid

MAA methacrylic acid

ALMA allyl methacrylate

DAP diallyl phthalate

BGDA butylene glycol diacrylate

VSM-1 (a.i.) cetyl-stearyl (EO)₂₀ methacrylate

EXAMPLE 2

Triggered response of thin films from multi-stage polymers as compared to single stage emulsion polymers:

Thin films cast on glass slides preparations: Polymer thin films with a thickness of about 20µm were prepared by first pre-neutralizing a multi-stage polymer emulsion to a desired pH with an aqueous solution of 0.1 M NaOH, then casting the emulsion onto a glass slide, and drying on a hot plate at 60 to 70°C for 20 to 30 minutes.

Free standing films preparation: Free standing polymer films were prepared by casting 1 gram of a pre-neutralized emulsion onto an aluminum weighing pan and drying at 70°C in a ventilated oven for 120 minutes. After the

film was dry, the free standing film with thickness of 100 to 200 μm was peeled off from the aluminum weighing pan. Films prepared from a single staged emulsion polymer were compared with films prepared from a multi-staged emulsion polymer and are summarized in Table 1.4.

5 Table 1.4

Sample	Compositions	Comments
Comparative Single staged Emulsion Polymer	10QM/60EA/20AA/10MAA/0.2DAP	Poor wet strength.
Multi-stage Emulsion Polymer	1 st stage DR 3858 (90%) /2 nd stage 95 MMA/5 ALMA (10%)	10% highly cross-linked non ASE/HASE compositions incorporated in 2 nd stage to improve wet strength.

Beaker test of thin films cast onto glass slides

The swelling properties of the polymer films DR 3858, 4099, 4102 and
 10 4110 were studied via thin films cast onto glass slides. The thin films cast onto
 glass slides were prepared by casting the emulsion onto the slides and then
 drying the films in a 60°C oven for 20 minutes. The dried films were put into a
 beaker containing 0.5% OMO detergent tablet solution, and the beaker was
 placed in a 60°C water bath. Photos were taken after the films were swelled in
 15 the detergent solution for 10 minutes. When the films were placed in detergent
 solution, the films started to swell. The swollen film of the single stage polymer
 exhibited weak mechanical strength and it lost integrity, falling off glass slides.
 Whereas films prepared from multi-staged emulsion polymers swelled under the
 same conditions and all maintained integrity on the glass slides.

20

Terg-O-Tometer® test: Free standing films were tested in a Terg-O-Tometer.
 Test conditions are the following:

A: wash conditions:

Detergent concentration: 0.6% Tide powder detergent;

25 Temperature: 25°C;

Agitation: 90 RPM;

Hardness of the wash water: 300 ppm.

Fabric added: 5 gram black cotton cloth.

Washing time: 15 minutes

A multi-stage polymer film (0.2 gram) was dosed in a 1-liter Terg pot and washed at 25°C. After a washing cycle, the wash water was filtered using a screen with pore size smaller than 100 mesh.

B: Rinse Conditions:

Temperature: Room temperature;

Agitation: 90 RPM;

10 Fabric added: 5 gram;

Time: 5 minutes.

The wash stability of films prepared from a single staged emulsion polymer were compared with films prepared from a multi-staged emulsion polymer and are summarized in Table 1.5.

Table 1.5 Wash stability of free standing films.

Sample	Compositions	Film thickness (μm)	Wash Conditions 40°C, 30 min	Rinse RT, 30 min
Single stage emulsion polymer	10QM/60EA/20AA/10MAA/0.2DAP	100	Film dissolved	
Multi stage emulsion polymer	10QM/60EA/20AA/10MAA/0.2DAP 2 nd stage 95 MMA/ALMA (10%) 5	100	5 min after, film turned clear, swollen, & gelatinous, survived wash cycle	invisible after 30 minutes

The use of multi-stage polymer particles as ionic strength responsive barrier materials to encapsulate active ingredients and to subsequently achieve triggered release of the actives in a rinse cycle overcomes the problem of the active or beneficial agent prematurely dispersing in to the aqueous system as a result of shear induced agitation. Polyelectrolytes including multi-stage polymer particles have significantly improved wet mechanical strength in aqueous systems and have utility as barrier materials, encapsulating agents and devices

for the triggered delivery/release of fabric care active ingredients and other related beneficial agents to an environment of use.

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